

Date: Wednesday, 1/11/2006 4:30:08 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEBBING TIDY		
Job Number	: 25479					
Estimate Number	: 11381					
P.O. Number	: N/A			Part Number	: D32153	
This Issue	: 1/11/2006 S.O. No. : N/A			Drawing Number	: D3215 REV C	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: C	
Previous Run	: N/A			Material	: N/A	
Written By	: See Comment Below			Due Date	: 1/31/2006	
Checked & Approved By	: Kim Johnston			Qty:	190	Um: Each
Comment	: Est. A04.01.06. New issue KJ/RF					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S040	5052-H32 .040 Sheet	
		Comment: Qty.: 0.0271 sf(s)/Unit Total : 5.1471 sf(s) 5052-H32 .040 Sheet Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S.040) Identify for D3215-3A Batch: M15982	
2.0	SHEAR	SHEAR	
		Comment: SHEAR	
3.0		along 2.562"	 Comment: J.F. 06/01/28 x 200
		HAAS CNC VERTICAL MACHINING #1	
4.0		JING #1 FA376 and dimensions	 Comment: J.F. 06/01/28 x 200
		INSPECT PARTS AS THEY COME OFF MACHINE	
5.0		DOME OFF MACHINE	 Comment: J.F. 06/01/28
		LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 Deburr	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:30:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 25479

Part Number: D32153

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

RG 06.01.28 200

7.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0271 sf(s)/Unit Total : 5.1471 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S.040)

Identify as D3215-3B

Batch: M17400

8.0 SHEAR SHEAR



Comment: SHEAR

Cut blank: 2.130" x 0.530"

Deburr D3215-3A/3B

RG 06.01.28 200

9.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

SB 06/01/31 200

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DA 06/01/31

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

Identify as D3215-3

Grind flush

SB 06/02/09 207  
PRO

CPL 06.02.08

12.0 QC5/9 WELD INSPECTION

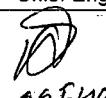
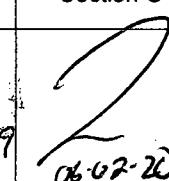
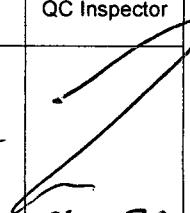


Comment: WELD INSPECTION

DA 06/02/09 207

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/02/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/02/09	4	I was scrap	 as per	Scrap & destroy	SP 06/02/09	 06-02-20	 as per	 06-02-20

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:30:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 25479

Part Number: D32153

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 06/02/16

14.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-02-17

15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06/02/17

16.0 PACKAGING 1 PACKAGING RESOURCE #1



FD + STC

Comment: PACKAGING RESOURCE #1

c 06/02/17 207

17.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5uc 06/02/20

207

06/02/20

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25479
Description: Webbing Tidy	Part Number:	D3215-3
Inspection Dwg: D3215 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

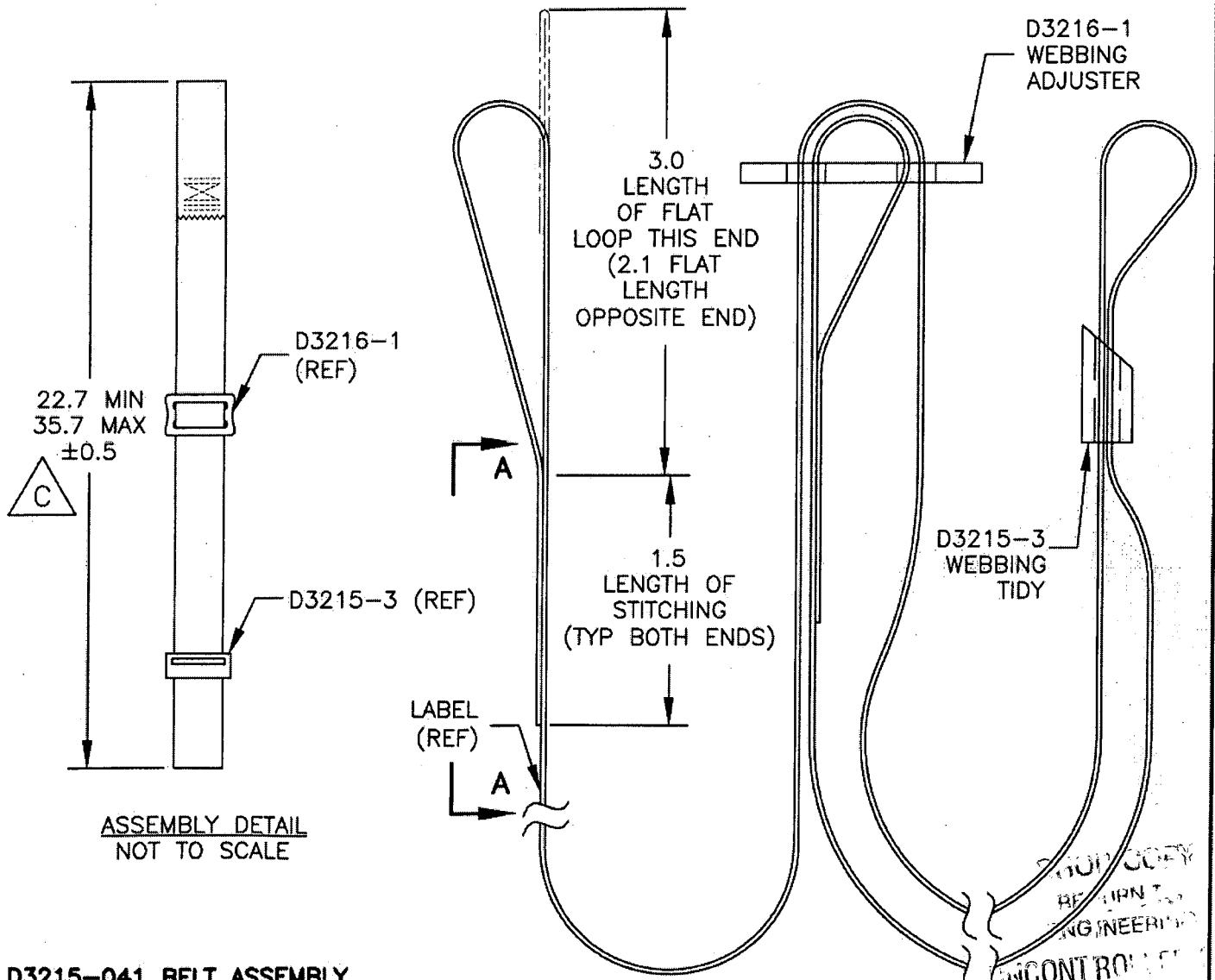
## X First Article      Prototype

Measured by:	J-F.	Audited by:	SA	Prototype Approval:	N/A
Date:	28/01/06	Date:	06.01.28	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	04.02.10	New Issue	KJ/RF	

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3215	SHEET 1 OF 3
DATE		TITLE	SCALE
04.03.05		BELT ASSEMBLY	NTS
A	03.09.19	NEW ISSUE	
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE	
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING	

**RELEASED**  
 04.03.05
**D3215-041 BELT ASSEMBLY**

1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472  
 (2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, CERTIFIED  
 TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN)

THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD  
 LABEL = TYVEK

2) ALL DIMENSIONS ARE IN INCHES  
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

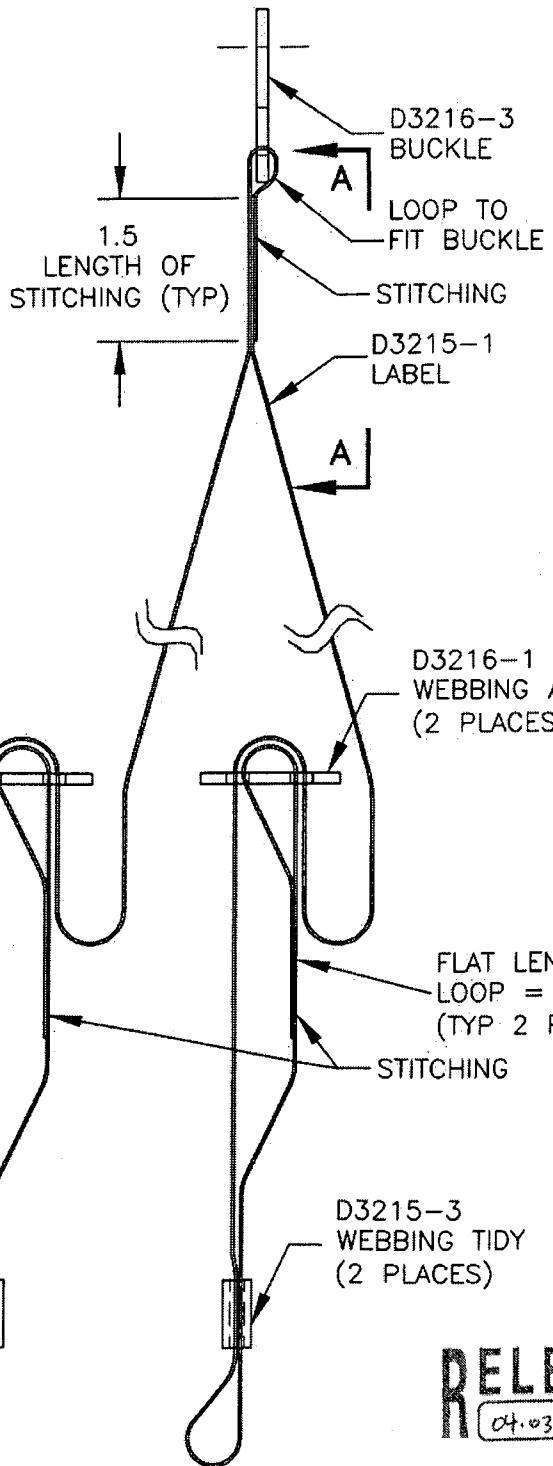
SUBJECT TO

NOMR

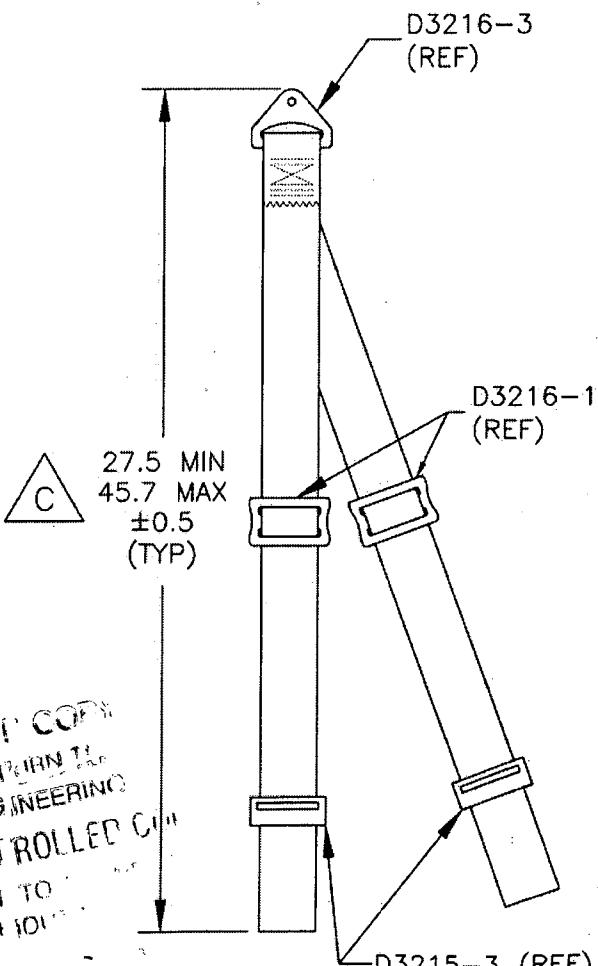
AC 25479

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>QP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3215	REV. C SHEET 2 OF 3
DATE 04.03.05		TITLE BELT ASSEMBLY	SCALE NTS

**D3215-043 BELT ASSEMBLY**

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472  
(2" WIDE x 0.060" THICK  
BLACK POLYESTER WEBBING,  
CERTIFIED TO FAR 29.853A3,  
TENSILE STRENGTH 5700 LB MIN)  
THREAD = VT 295 TYPE II CLASS A SIZE 3,  
BLACK NYLON THREAD  
LABEL = TYVEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED.



**RELEASED** *UPW* *25479*  
*04.03.08*

ASSEMBLY DETAIL  
NOT TO SCALE

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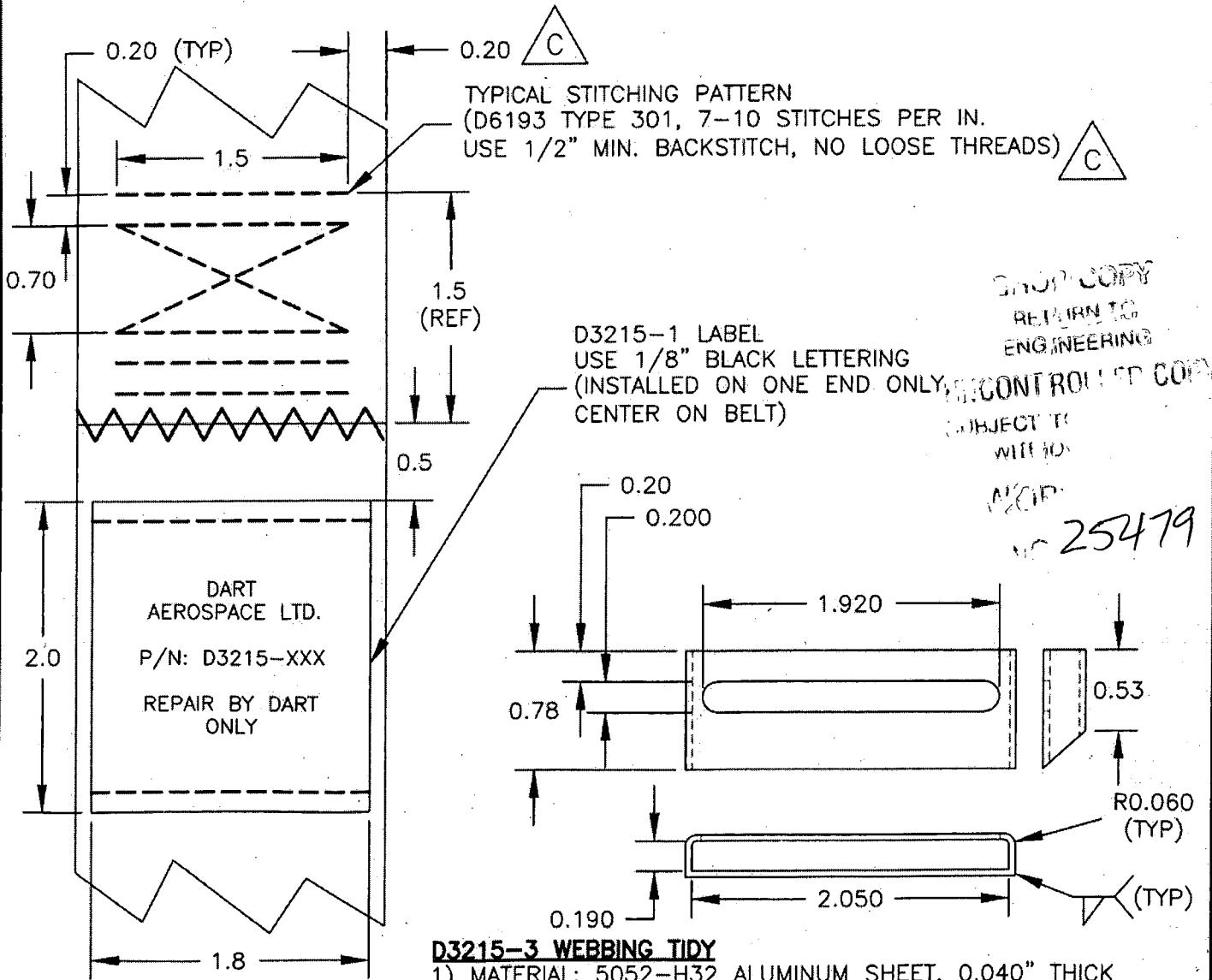
**DART**

DESIGN	4P	DRAWN BY	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3215
DATE	04.03.05	TITLE	Harness Assembly	

REV. C  
SHEET 3 OF 3  
SCALE 1:1

**VIEW A-A**

XXX = 041 FOR D3215-041  
 XXX = 043 FOR D3215-043

**RELEASED**  
*04.03.05*